

Date: Wednesday, 3/8/2006 10:40:39 AM  
 User: Kim Johnston

## Process Sheet

*Split 8B 06/05/14 15*

Customer : CU-DAR001 Dart Helicopters Services  
 Job Number : 26136  
 Estimate Number : 12027  
 P.O. Number : N/A  
 This Issue : 3/8/2006 S.O. No. : N/A  
 Prsht Rev. : NC  
 First Issue : N/A Type : LARGE FAB ASSY  
 Previous Run : 25908  
 Drawing Name : PILOT/CO-PILOT STEP, RH (FOLDING)  
 Part Number : D412630024  
 Drawing Number : D412-630 REV: J, P13  
 Project Number : N/A  
 Drawing Revision : J  
 Material : N/A  
 Due Date : 4/15/2006  
 Qty: *2* Um: *4* Each  
 Written By : *See comment below*  
 Checked & Approved By : *06.03.08*  
 Comment : Est. Rev: B 05.08.22 Step 3 & 5 revised per ECN 700 KJ/J LM

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile &amp; create labels per PPP D412-630-024 CHG002

*DH 06/03/07 (4)*

2.0 D2012107 Clevis



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Clevis

Pick:

Qty	Part Number	Description
1	D2012-107	Clevis

Batch

*B25483 -*

3.0 D2803042 Bracket Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Bracket Assembly

Pick:

Qty	Part Number	Description
1	D2803-042	Bracket Assembly RH

Batch

*B25918 -*

4.0 D2804042 Bracket Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Bracket Assembly

Pick:

Qty	Part Number	Description
1	D2804-042	Bracket Assembly RH

Batch

*B25920-2 -*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PILOT/CO-PILOT STEP, RH (FOLDING)

Job Number: 26136

Part Number: D412630024

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D2807

Support Prop



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)  
Support Prop

Pick:

Qty	Part Number	Description
2	D2807	Gas Spring

Batch

B25247 /

6.0

D2813

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)  
Washer

Pick:

Qty	Part Number	Description
2	D2813	Washer

Batch

B26649 /

7.0

D33951

Bushing



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)  
Bushing

Pick:

Qty	Part Number	Description
4	D3395-1	Bushing

Batch

B26584 /

8.0

D3388042

Step Weldment RH



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
Step Weldment RH

B26653-1 /

9.0

AN3C21A

BOLT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)  
BOLT

Pick:

Qty	Part Number	Description
2	AN3C21A	Bolt

Batch

118648 M19633 /

10.0

AN310C8

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)  
Nut

Pick:

Qty	Part Number	Description

Batch

M18515 /



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PILOT/CO-PILOT STEP, RH (FOLDING)

Job Number: 26136

Part Number: D412630024

Job Number:



Seq. #:

Machine Or Operation:

Description :

2 AN310C8 Nut

M18515

11.0

AN8C16

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

Pick:

Qty	Part Number	Description
2	AN8C16	Bolt

Batch

~~M17714~~ M18779 /

12.0

MS210433

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Nut

Pick:

Qty	Part Number	Description
4	MS21043-3	Nut

Batch

M100218 /

13.0

MS24665302

Cotter Pin



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Cotter Pin

Pick:

Qty	Part Number	Description
2	MS24665-302	Cotter Pin (or AN380C3-4)

Batch

M16941 /

14.0

MS24693C280

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Screw

Pick:

Qty	Part Number	Description
2	MS24693-C280	Screw (or MS24694-C565)

Batch

M16984 /

15.0

NAS1515H3

Washer



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Washer

Pick:

Qty	Part Number	Description
6	NAS1515H3	Washer

Batch

M19633 /

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PILOT/CO-PILOT STEP, RH (FOLDING)

Job Number: 26136

Part Number: D412630024

Job Number:



Seq. #:

Machine Or Operation:

Description :

16.0

NAS1515H5L

WASHER



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

WASHER

Pick:

Qty	Part Number	Description
4	NAS1515H5L	Washer

Batch

M18535 (7) M100050 (1)

17.0

NAS1515H8

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Washer

Pick:

Qty	Part Number	Description
4	NAS1515H8	Washer

Batch

M18979 SAN 06:05:16 (2)

18.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per dwg D412-630 p.13

SAN 06:05:16 (2)

19.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 04/05/03 (2)

20.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

21.0

D28061

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bushing

Pick: Packing Kit

Qty	Part Number	Description
2	D2806-1	Bushing

Batch

B25921 v



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PILOT/CO-PILOT STEP, RH (FOLDING)

Job Number: 26136

Part Number: D412630024

Job Number:



Seq. #:

Machine Or Operation:

Description :

22.0

D28063

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)  
Bushing

Pick: Packing Kit

Qty Part Number

Description

Batch

2 D2806-3

Bushing

B25922x7V  
B26160x2V B25869xV

23.0

D28105

Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
Strut

Pick: Packing Kit

Qty Part Number

Description

Batch

1 D2810-5

Strut

B26758 3 m4

24.0

D33961

Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)  
Spacer

Pick: Packing Kit

Qty Part Number

Description

Batch

2 D3396-1

Spacer

B24645V

25.0

AN4C6A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
Bolt

Pick: Packing Kit

Qty Part Number

Description

Batch

1 AN4C6A

Bolt

M19512 ✓

26.0

AN4C10A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
Bolt

Pick: Packing Kit

Qty Part Number

Description

Batch

1 AN4C10A

Bolt

M18515 ✓

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PILOT/CO-PILOT STEP, RH (FOLDING)

Job Number: 26136

Part Number: D412630024

Job Number:



Seq. #:

Machine Or Operation:

Description :

27.0

AN4C15A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : ~~2.0000~~ Each(s)

Bolt

Pick: Packing Kit

Qty Part Number

2 AN4C15A

Description

Bolt

Batch

M19600 ✓

28.0

AN44C7A

Eyebolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : ~~1.0000~~ Each(s)

Eyebolt

Pick: Packing Kit

Qty Part Number

1 AN44-C7A

Description

Eyebolt

Batch

M19620 ✓

29.0

AN5C15A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : ~~2.0000~~ Each(s)

Bolt

Pick: Packing Kit

Qty Part Number

2 AN5C15A

Description

Bolt

Batch

M18167 ✓

30.0

MS210434

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : ~~4.0000~~ Each(s)

Nut

Pick: Packing Kit

Qty Part Number

4 MS21043-4

Description

Nut

Batch

M100651 ✓

31.0

MS210435

Nut



Comment: Qty.: 3.0000 Each(s)/Unit Total : ~~3.0000~~ Each(s)

Nut

Pick: Packing Kit

Qty Part Number

3 MS21043-5

Description

Nut

Batch

M18535 ✓



Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA: TD Date: 06/05/24  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PILOT/CO-PILOT STEP, RH (FOLDING)

Job Number: 26136

Part Number: D412630024

Job Number:



Seq. #:

Machine Or Operation:

Description :

32.0

NAS1515H4

Washer



Comment: Qty.: 7.0000 Each(s)/Unit Total : 7.0000 Each(s)

Washer

Pick: Packing Kit

Qty Part Number

7 NAS1515H4

Description

Washer

Batch

7100680 ✓

33.0

NAS1515H5

Washer



Comment: Qty.: 7.0000 Each(s)/Unit Total : 7.0000 Each(s)

Washer

Pick: Packing Kit

Qty Part Number

7 NAS1515H5

Description

Washer

Batch

719565 ✓

SP 06/05/19 (5)

34.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

SP 06/15/23 (5)

35.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-630-024

Location:

PPP Rev: A

SP 06/05/24 (2)

36.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

SP 06/05/24 (2)

Job Completion



SP 06/03/24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



Date: Wednesday, 3/8/2006 10:40:39 AM  
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## Process Sheet

15

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : PILOT/CO-PILOT STEP, RH (FOLDING)  
 Job Number : 26136  
 Estimate Number : 12027  
 P.O. Number :  
 This Issue : 3/8/2006 S.O. No. :  
 Prsht Rev. : NC Part Number : D412630024  
 First Issue : / / Type : LARGE FAB ASSY Drawing Number : D412-630 REV. J ,P13  
 Previous Run : 25908 Drawing Revision : J  
 Material :  
 Due Date : 4/15/2006 Qty: 1 Um: Each  
 Written By :  
 Checked & Approved By : KA 06.03.08  
 Comment : Est. Rev: B 05.08.22 Step 3 & 5 revised per ECN 700 KJ/J  
 LM

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile &amp; create labels per PPP D412-630-024 CHG002

DA 3/29/06

2.0 D2012107 Clevis



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Clevis

Pick:

Qty	Part Number	Description	Batch
1	D2012-107	Clevis	

3.0 D2803042 Bracket Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Bracket Assembly

Pick:

Qty	Part Number	Description	Batch
1	D2803-042	Bracket Assembly RH	

4.0 D2804042 Bracket Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Bracket Assembly

Pick:

Qty	Part Number	Description	Batch
1	D2804-042	Bracket Assembly RH	

REFERENCE ONLY

Date: Wednesday, 5/24/2006 9:01:25 AM

User: Chantal Lavoie

# **INVENTORY ITEMS PICKED FOR SLIP NUMBER 2487**

Project No. : N/A  
 Customer : Dart Helicopters Services  
 Part Number : D412630024  
 Job Number : 26136

Drawing Number : D412-630 REV. J ,P13  
 Drawing Name : PILOT/CO-PILOT STEP, RH (FOLDING)  
 Due Date : / /  
 Qty : 2  
 Slip # : 2487

		Location	Store	Picking	Lot No.	Serial No.	Req'd	Taken
2.0	D2012107 Clevis Available 67.00	MAIN		ST016	25483		2.00	2.0000 Each
3.0	D2803042 Bracket Assembly Available 18.00	MAIN		ST156	25918		2.00	2.0000 Each
4.0	D2804042 Bracket Assembly Available 11.00	MAIN		ST156	25920		2.00	2.0000 Each
5.0	D2807 Support Prop Available 8.00	MAIN		ST387	25247		4.00	4.0000 Each
6.0	D2813 Washer Available 159.00	MAIN		ST388	26649		4.00	4.0000 Each
7.0	D33951 Bushing Available 103.00	MAIN		ST432	26584		8.00	8.0000 Each
8.0	D3388042 Step Weldment RH Available 2.00	MAIN			26653		2.00	2.0000 Each
9.0	AN3C21A BOLT Available 115.00	MAIN		ST309	19633		4.00	4.0000 Each
10.0	AN310C8 Nut Available 122.00	MAIN		ST311	18515		4.00	4.0000 Each
11.0	AN8C16 Bolt Available	MAIN		ST280	18779		4.00	4.0000 Each
12.0	MS210433 Nut Available 676.00	MAIN		ST262	100218		8.00	8.0000 Each
13.0	MS24665302 Cotter Pin Available 319.00	MAIN		ST243	16941		4.00	4.0000 Each
14.0	MS24693C280 Screw Available 89.00	MAIN		ST244	16984		4.00	4.0000 Each
15.0	NAS1515H3 Washer Available 1865.00	MAIN		ST231	19633		12.00	12.0000 Each

Date: Wednesday, 5/24/2006 9:01:25 AM

User: Chantal Lavoie

# **INVENTORY ITEMS PICKED FOR SLIP NUMBER 2487**

16.0	NAS1515H5L WASHER						
Available	415.00	MAIN	ST231	100050	8.00	8.0000 Each	
		MAIN	ST231	17569	8.00	8.0000	
17.0	NAS1515H8 Washer						
Available	128.00	MAIN	ST231	18779	8.00	8.0000 Each	
21.0	D28061 Bushings						
Available	71.00	MAIN	ST387	25921	4.00	4.0000 Each	
22.0	D28063 Bushings						
Available	66.00	MAIN	ST387	26160	4.00	4.0000 Each	
23.0	D28105 Strut						
Available	5.00	MAIN	ST162	26758	2.00	2.0000 Each	
24.0	D33961 Spacer						
Available	21.00	MAIN	ST432	24645	4.00	4.0000 Each	
25.0	AN4C6A Bolt						
Available	434.00	MAIN	ST313	19512	2.00	2.0000 Each	
26.0	AN4C10A Bolt						
Available	85.00	MAIN	ST313	18515	2.00	2.0000 Each	
27.0	AN4C15A Bolt						
Available	159.00	MAIN	ST315	19600	4.00	4.0000 Each	
28.0	AN44C7A Eyebolt						
Available	103.00	MAIN	ST317	19620	2.00	2.0000 Each	
29.0	AN5C15A Bolt						
Available	145.00	MAIN	ST295	18167	4.00	4.0000 Each	
30.0	MS210434 Nut						
Available	478.00	MAIN	ST262	100651	8.00	8.0000 Each	
31.0	MS210435 Nut						
Available	189.00	MAIN	ST262	18535	6.00	6.0000 Each	
32.0	NAS1515H4 Washer						
Available	306.00	MAIN	ST231	100680	14.00	14.0000 Each	
33.0	NAS1515H5 Washer						
Available	529.00	MAIN	ST231	19565	14.00	14.0000 Each	